

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023931**Date Inspected:** 20-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG 13AE, 13BE, 13CE, 14E**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

TRIAL ASSEMBLY YARD

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 09195 from ZPMC for Trial Assembly Yard. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as 13AE. The weld designations reviewed are as follows.

SEG3007AH-099, 108, 163

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 09194 from ZPMC for Trial Assembly Yard. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as 13BE. The weld designations reviewed are as follows.

SEG3009E-207

SEG3009J-227

SEG3009V-004~025, 040~042

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector observed the following work in progress for Trial Assembly Yard.

ZPMC was using the Shielded Metal Arc Welding and Flux Cored Arc Welding (SMAW FCAW).

ZPMC QC is identified as Wang Xiang Pin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: DP Diaphragm to LD

PCMK: SEG3019K

Weld Number: 005

Welder: 044779

WPS-345-SMAW-2G-Repair-FCM

WR-20937

Component: I Rib to BP Holdback

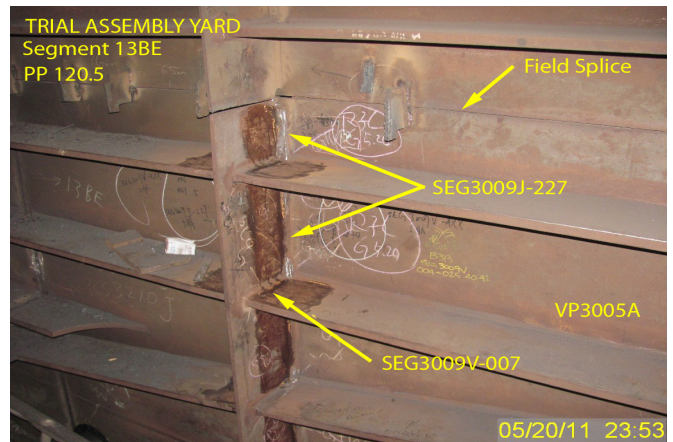
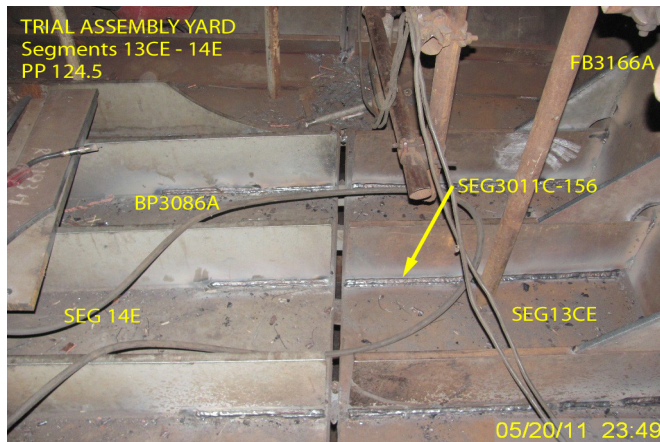
PCMK: SEG3011C

Weld Number: 156, 157

Welder: 050977

WPS-B-T-2132

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Combs,Dennis

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer